

Work Order ID 78434

Monday, January 09, 2012 1:09:33 PM

78434

Page 1

Item ID: D3891-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel, Fwd LH

Start Date: 1/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-01-09* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3891

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3891-1

Dwg Rev: *1*

Prog Rev: *1*

2-Deburr if necessary

0.00

B12-1-9

1

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12-1-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78434

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Page 2

Item ID: D3891-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Panel, Fwd LH

Stop

NS2

Start Date: 1/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/12/01/09

ⓧ

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

u/45

140

Pick Kit

0.00

140

Packaging

Memo

0.00

Packaging

8/12/01/10 ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78434***78434***

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Monday, January 09, 2012 1:09:33 PM

Item ID: D3891-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Panel, Fwd LH

Start Date: 1/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 7112597

160

0.00

160

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

170

0.00

170

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

PM
77898

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78434***78434***


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Monday, January 09, 2012 1:09:33 PM

Item ID: D3891-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel, Fwd LH
Start Date: 1/9/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/10/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/11 
mf
12-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 09, 2012 1:09:33 PM

Page 1

Work Order ID: 78434

Parent Item: D3891-041

Parent Item Name: Panel, Fwd LH

Start Date: 1/9/2012

Required Date: 1/10/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	2,072.5000	4.656	4.9010526			

B12-1-9

Location

Loc Qty

Loc Code

MAT019

2072.5

119937

2072.5

D3891-3

Manufactured No

140 Each 0.0000

Gasket

1

1

B78333 (1x)

119937

12/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

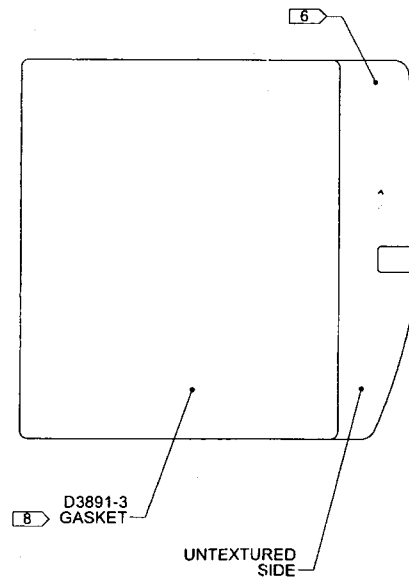
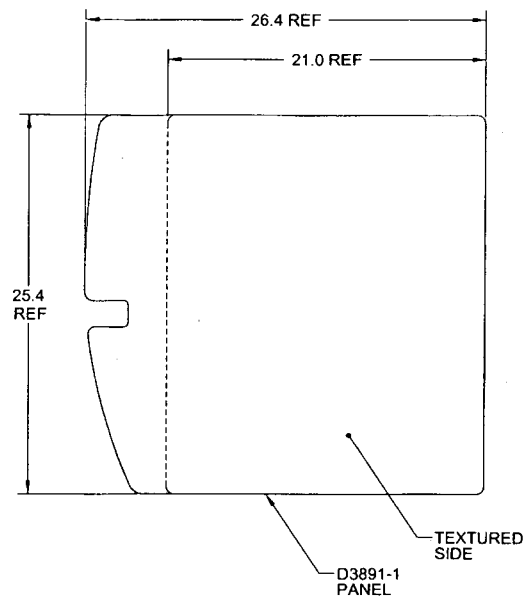
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-041 PANEL, FWD LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

#78434

RELEASED
09/06/16

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	09.05.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3891
REV. A
SHEET 1 OF 6
TITLE PANEL, FWD
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

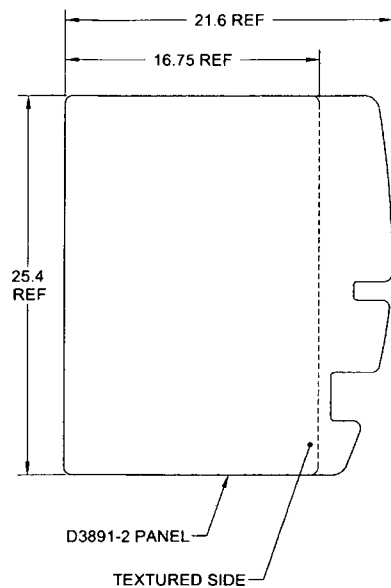
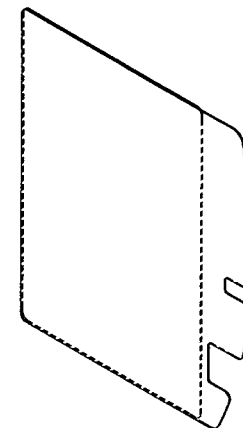
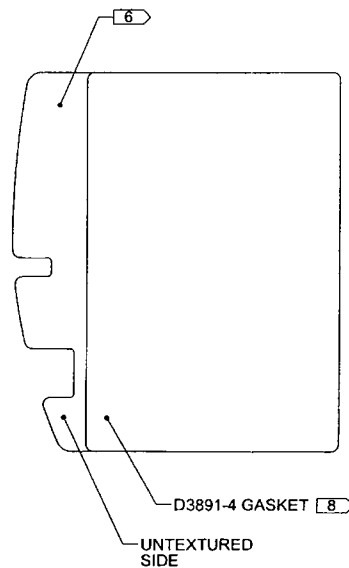
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-042 PANEL, FWD RH**

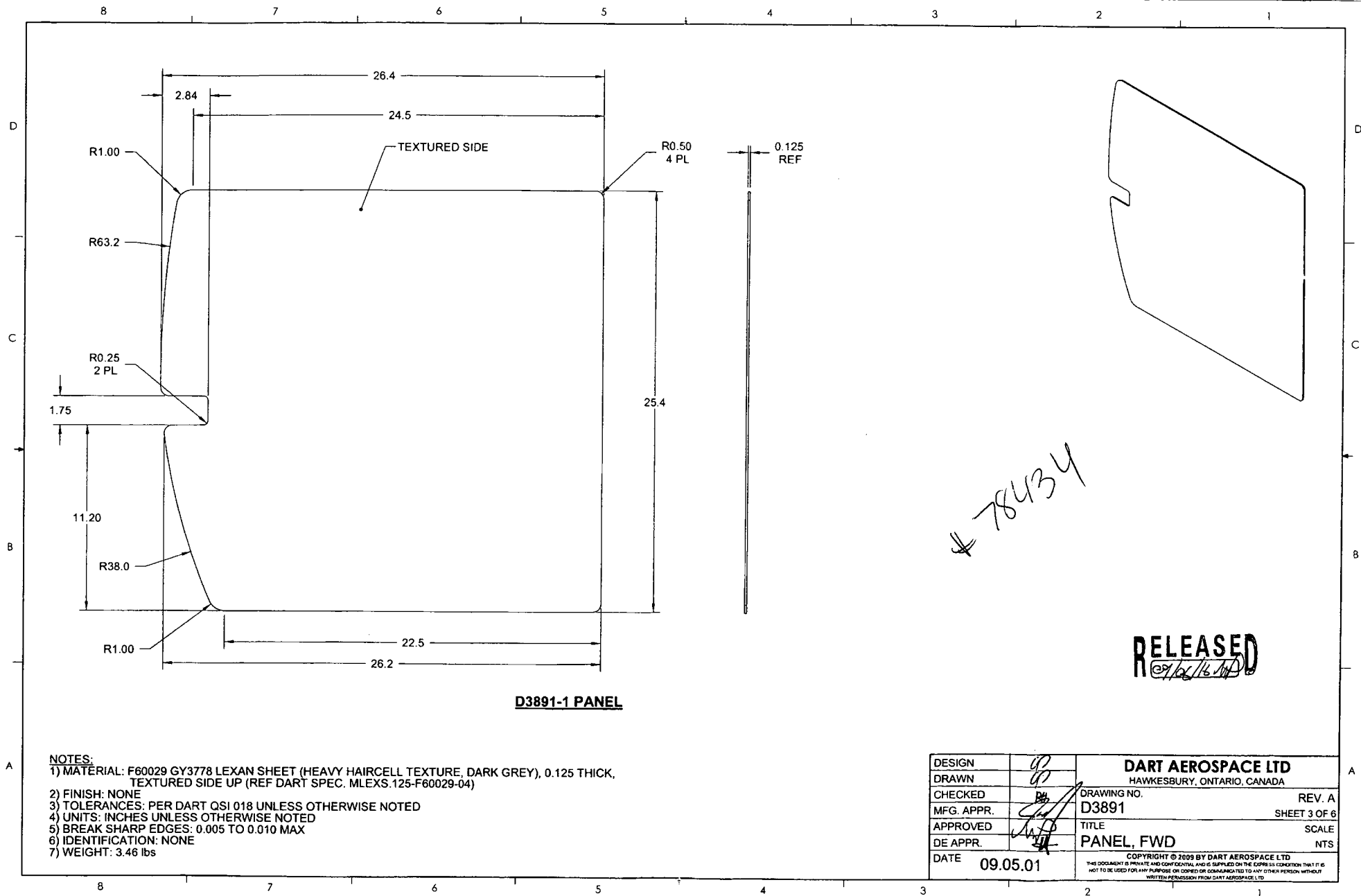
#78424

RELEASED
09/05/01

NOTES:

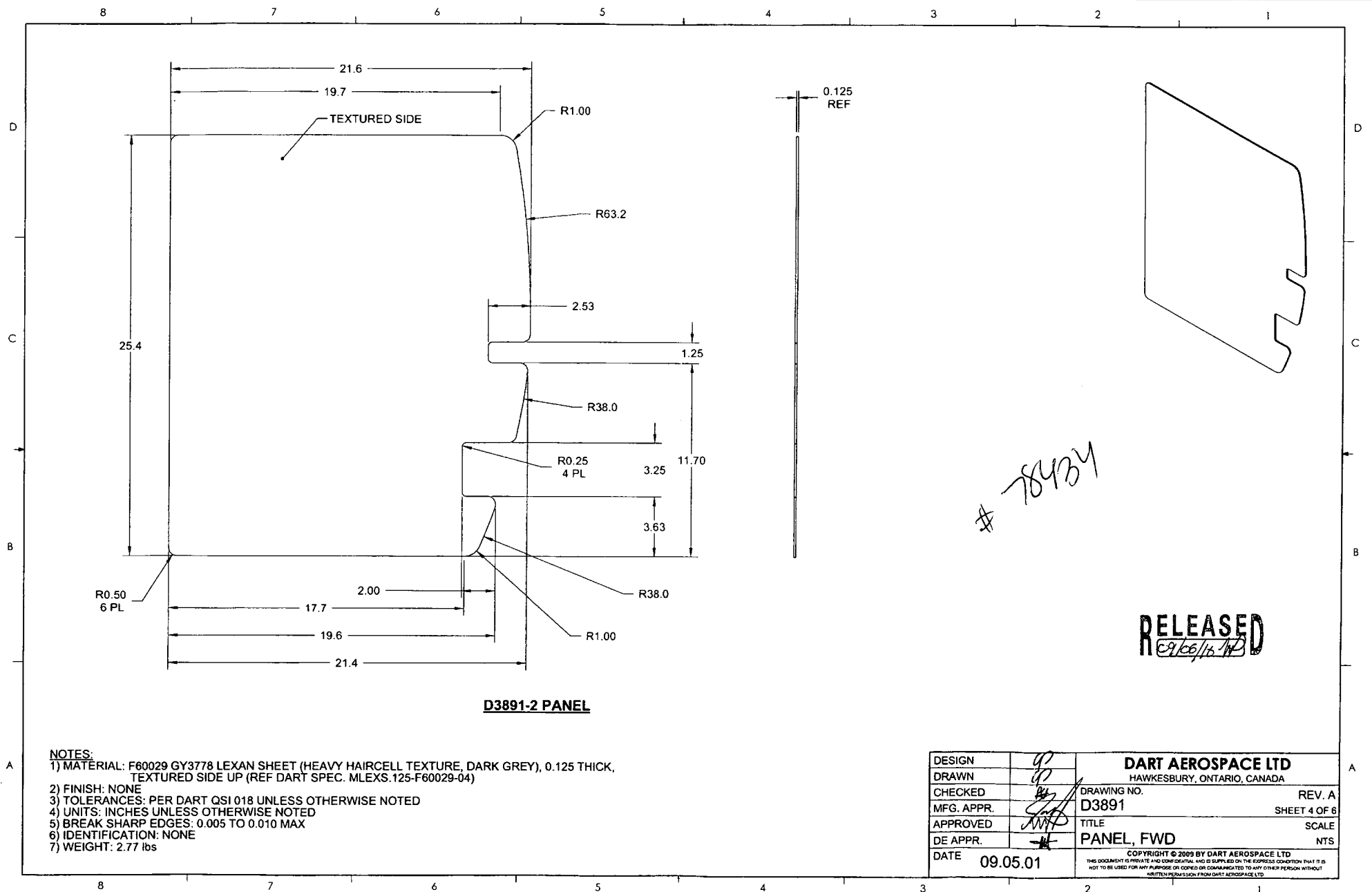
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

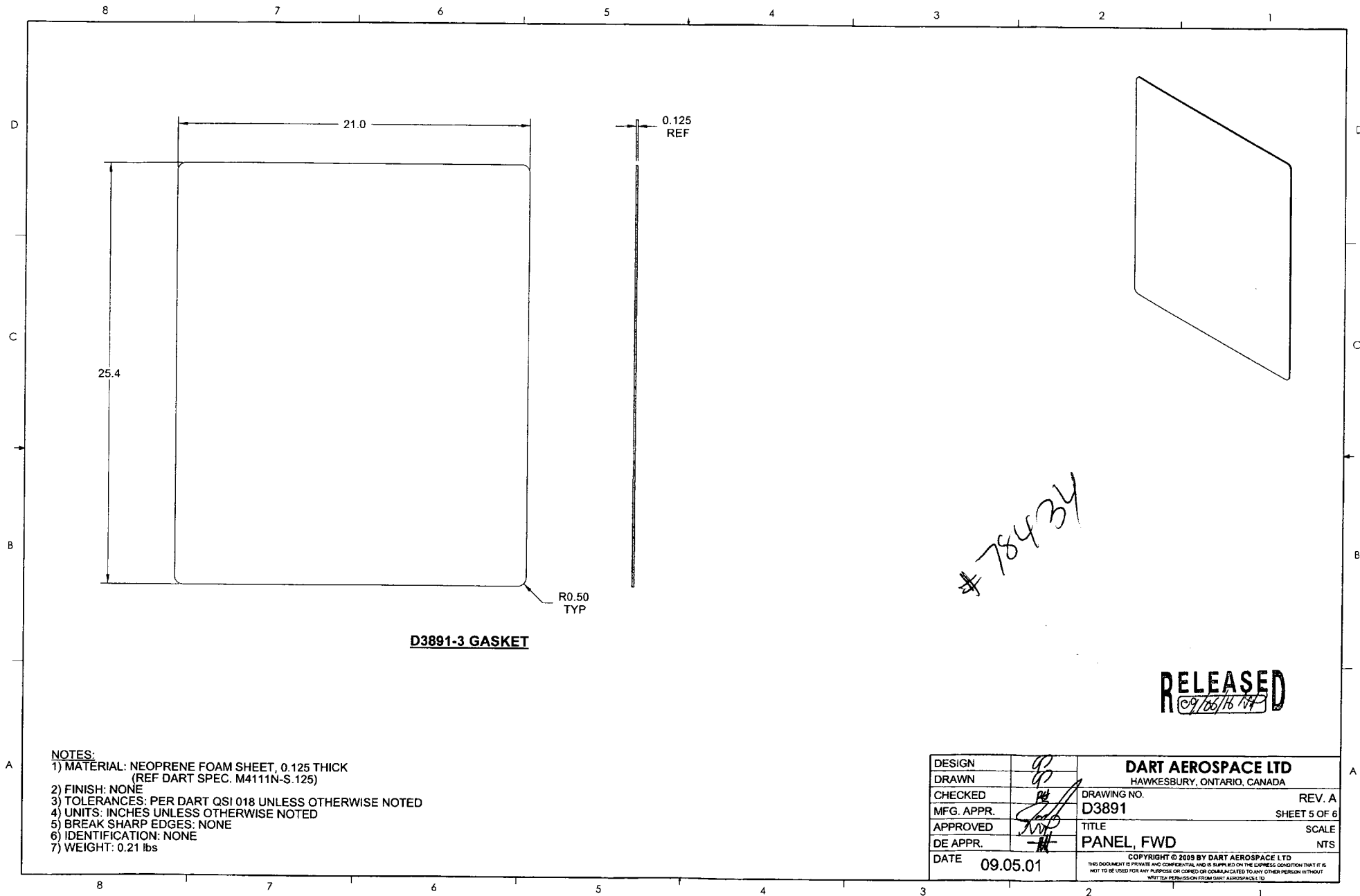
DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	GP	D3891	SHEET 2 OF 6
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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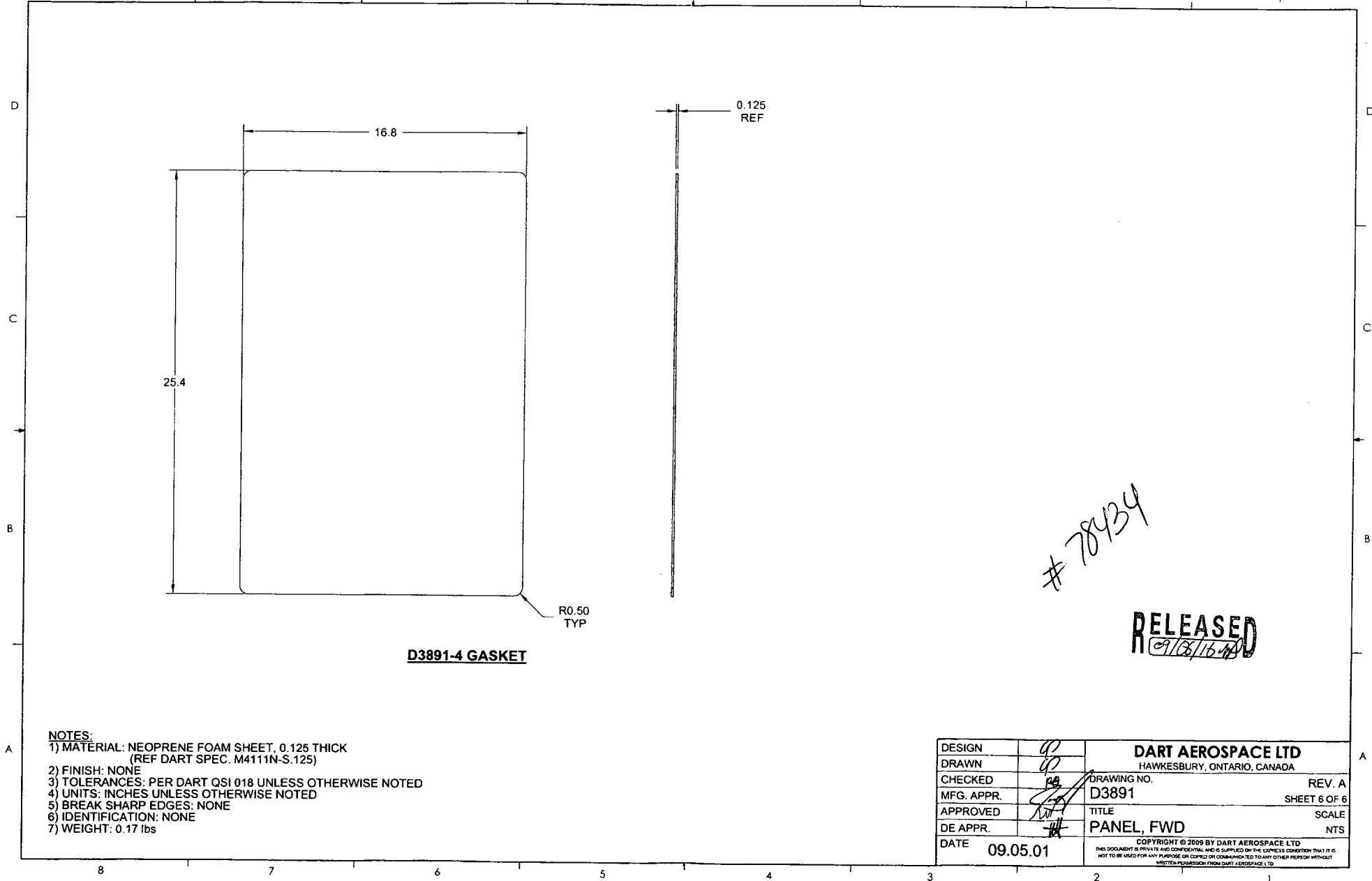


RELEASED
07/04/16

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 3 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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DART AEROSPACE LTD		Work Order:	78434
Description: Panel		Part Number:	D3891-1
Inspection Dwg: D3891	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.84	+/-0.030	2.84	✓		T B01	
26.4	+/-0.100	26.4	✓		T	
24.5	+/-0.100	24.5	✓		T	
25.4	+/-0.100	25.4	✓		T	
22.5	+/-0.100	22.5	✓		T	
26.2	+/-0.100	26.2	✓		T	
11.20	+/-0.030	11.20	✓		T	
1.75	+/-0.030	1.745	✓		T	
0.125	+/-0.010	0.129	✓		✓ B02	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	12-1-09	Date:	12/4/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	